

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007936**Date Inspected:** 27-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**Contractor:** Japan Steel Works**Location:** Muroran, Japan

CWI Name:	Pin-Tang Hsu		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No N/A
Weld Procedures Followed:	Yes	No N/A
Verified Joint Fit-up:	Yes	No N/A
Approved WPS:	Yes	No N/A
Delayed / Cancelled:	Yes	No N/A
Component:	Tower, Jacking and Deviation Saddles	

Bridge No: 34-0006**Summary of Items Observed:**

On this date, 7/27/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections in Foundry and associated built up plate sections in the Fabrication shop #4 at Japan Steel Works (JSW), Muroran, Japan.

WEST DEVIATION SADDLES

W2W2 - Magnetic Particle Inspection being conducted by NIS technician R. Kumagai #132 was observed by QA to be testing welds joining Cast to plate. Excess material at locations of strongbacks were being cut away by K. Koyanagi 08-5144 utilizing an Oxy-Propane cutting torch.

W2W3 - Saddle section is being repositioned to accommodate the weld of "vertical" welds in a 1G position. Welding will commence upon preheat temperature verification by QC CWI Mr. Pin-Tang Hsu.

TOWER SADDLES

T1-2 - Saddle section has moved to No. 4 Machine shop for layout.

T1-3 - Saddle section is being repositioned to accommodate the weld of the opposing side of plate stem to base plate welds in a 2G position. Welding will commence upon preheat temperature verification by QC CWI Mr. Pin-Tang Hsu. This observation took place in the Fabrication Shop #4.

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EAST SADDLES

E2E1 - Cast section now located at the Heat Treatment shop, per JSW representative Mr. Hideaki Kon.

E2W1 - Casted section is undergoing wet Magnetic Particle Testing MT to its base by H.Kohama #86 of the JSW Foundry inspection team. Equipment in use was a contour probe/yoke in AC mode. A supplemental light is employed to assure minimum white light requirements are met. Located in Foundry Shop.

West Jacking Saddle - Cast Section is completely shaped and is in process of visual inspection (VT), numerous circled rejectable indications observed on surface. This cast section is located in the Foundry.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

No significant conversations to report on this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
